

# Work Order ID 57804 - 2

Thursday, April 15, 2010 11:35:11 AM



Page 1

Item ID: D3400-041

Accept



Setup Start



Revision ID:

Item Name: Collective Disabling Kit

Stop



Start Date: 4/15/2010 Start Qty: 2.00



Required Date: 4/23/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-4-15 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3400

Rev A

100



Small Fab

Small Fab

0.00

Memo

0.00

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5

SB 10/04/06

①

110



Small Fab

Small Fab

0.00

Memo

0.00

1-Assemble D3400-053 as per Dwg D3400. Apply a drop of permanent locktite 262 to the threads

A/R Locktite 262 Batch: M110005 Identify as D3400-053

2-Assemble D3400-051 as per Dwg

SB 10/04/06

①





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Page 2

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Customer:

Reference:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



Large Fab

Large Fab

Large Fab

Memo

Tack weld lock shaft as per Dwg D3400

A/R

SS Rod

Batch: 111679

0.00

0.00

①

Pl 10.04.26

130



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

①

Pl 10.04.27

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

C 10.04.27

②

Fe



Order ID 57804



Monday, April 15, 2010 11:35:11 AM

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Start Date: 4/15/2010 Start Qty: 2.00



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Customer:

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Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Memo

*PNP 57795*

0.00

*6/14/27 D*

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/04/27*

*ME 10-4-27*





April 15, 2010 11:35:11 AM

Work Order ID: 57804

Parent Item: D3400-041

Parent Item Name: Collective Disabling Kit

Comments: IPP Rev:A new issue DD 10.04.15 verified by:EC

Start Date: 4/15/2010

Required Date: 4/23/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

5/16WC		Purchased	No			100	Each	378.0000	4.0000			
--------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--



SS Flat Washer 5/16

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST377

378

112560 ✓

378

D3369-5



Inventory

D3372-5



Cam Lock Shaft

Manufactured

No

100

Each

0.0000

2.0000



Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST052

25

22167

18

22290 ✓

7

D3373-1



Cam Lock

Manufactured

No

100

Each

16.0000

2.0000



Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST052

16

44105 ✓

16

10/04/21

m-l

4x

2x

m-l 10/04/21

10/04/21

m-l

2x

m-l

10/04/21

2





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Required Date: 4/23/2010

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Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3384-043 		Manufactured	No			100	Each	0.0000	2.0000		2x m-h 10/04/21	
Cyclic Sock Assembly D3400-1 		Manufactured	No			100	Each	10.0000	2.0000			
Main Body												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST487	10	
	22561	10	

Location

Main Warehouse

ST487

22561

10

10

D3400-3



Guide

D3400-5



Slider Body

Manufactured No

Manufactured No

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST487	12	
	22562	12	

Location

Main Warehouse

ST487

22562

12

12

Thursday, April 15, 2010 11:35:11 AM

Shop Packet Print





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Required Date: 4/23/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

HX-81

Purchased

No

100

Each

66.0000

2.0000



1/4"-20 SHCS 3/8" long

M 110383



2x m-l 10/04/21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST390

66

110383

16

114383

50

AN960-416

Purchased

No

100

Each

0.0000

4.0000



Washer

M 114223



10/04/21

4x m-l

NAS 1149F04631

238-028

Low Pin

Qty 4

Batch: M 17278

m-l 10/04/21

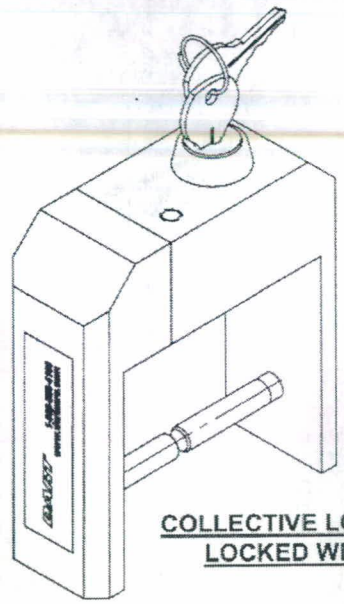




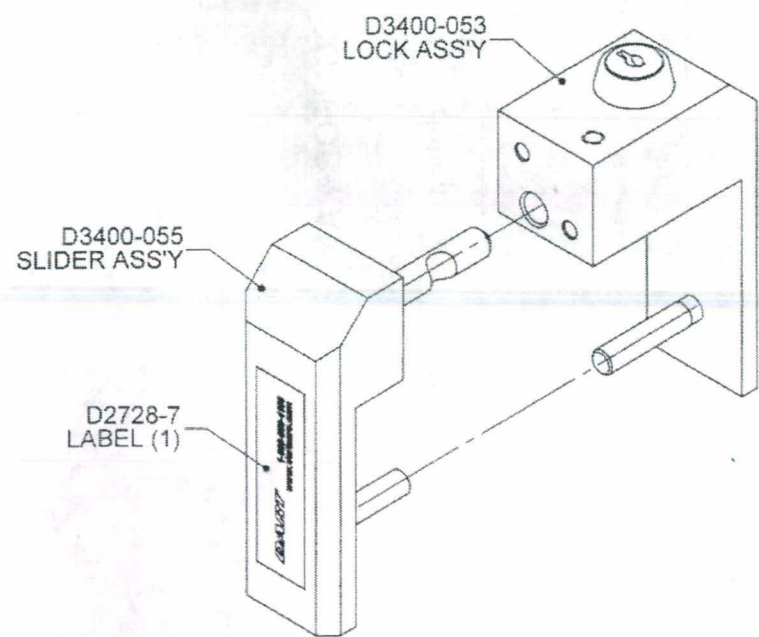
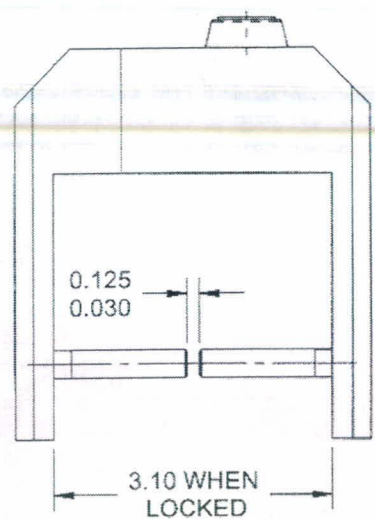


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3400	REV. A SHEET 1 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.02.23	NEW ISSUE	

RELEASED  
*[Signature]*  
05/04/23



**COLLECTIVE LOCK SHOWN  
LOCKED WITH KEYS**



#57804

**D3400-051 AS355 COLLECTIVE LOCK ASS'Y**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

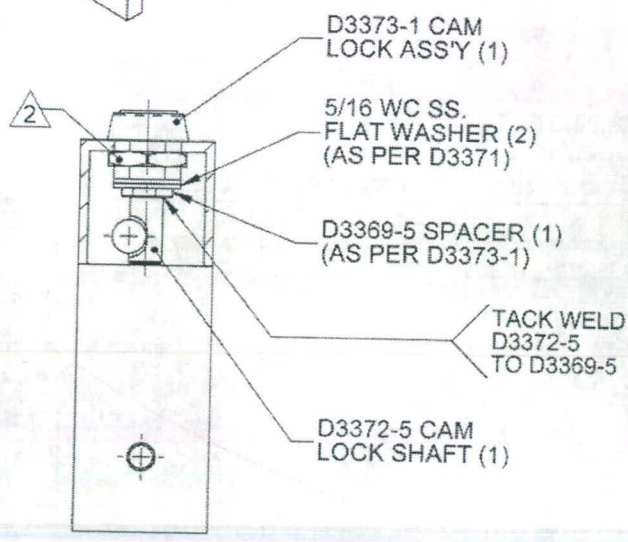
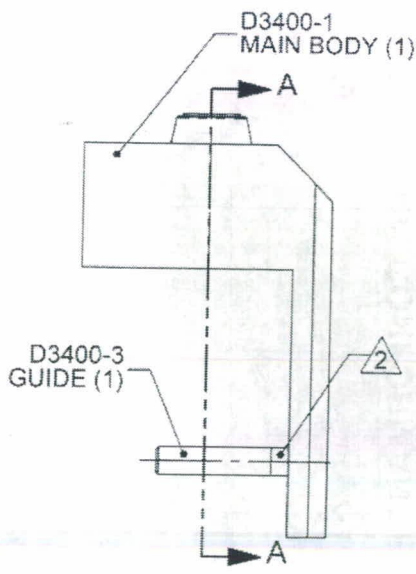
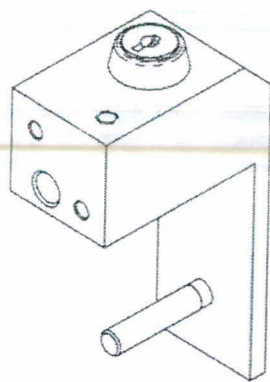




DESIGN 3	DRAWN BY 45	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 74	APPROVED 001	DRAWING NO. D3400	REV. A SHEET 2 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

RELEASED

25/64/28



**SECTION A-A**

**D3400-053 LOCK ASS'Y**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

NOTE: Use  
H-IFORMS Quality Assurance

#57804

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

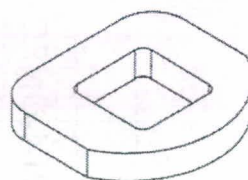
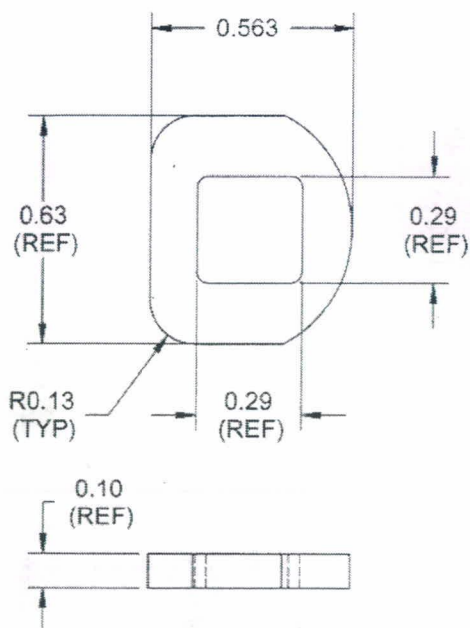
**NOTE:** Date & initial all entries





DESIGN <i>13</i>	DRAWN BY <i>13</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>13</i>	APPROVED <i>13</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16	TITLE BATTERY LOCK		SCALE 2:1

## SPECIFICATION CONTROL DRAWING



RELEASED  
*13*

05/02/11

-5  
**D3369 SPACER**



### NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries